

Date: Friday, 9/29/2006 10:38:04 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE
Job Number	: 28780		
Estimate Number	: 11545		
P.O. Number	:	Part Number	: D204635011
This Issue	: 9/29/2006 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 25691	Material	:
Written By	:	Due Date	: 10/22/2006 Qty: 1 Um: Each
Checked & Approved By	: <i>KA 06 09 29</i>		
Comment	: Est Rev:G 02.08.28 Removed QC5 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and Type labels as per PPP D204-635-011 CHG004

KS 06.10.11 ①

2.0

28780A

SKIDTUBE



Comment: Sub-Component Pick:

Qty Part Number Description Batch

1 D204-635-041 Skidtube Assembly *B28780A**LB 06/11/23* ① ✓

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0

K10003

D205-634-011 Saddle Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 K10003 Saddle Kit *B26848**LB 06/11/23* ① ✓

5.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

LB 06/11/23 ① ✓

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:38:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 28780

Part Number: D204635011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D204-635-011

Location: _____

PPP Rev: _____

B

LB 06/11/23 ①

4/6

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SP 06/11/23 ①

Job Completion



06/11/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

line D. a mis le label (note)

Date: Friday, 9/29/2006 10:38:44 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE
 Job Number : 28780A
 Estimate Number : 11546
 P.O. Number : *N/A* Part Number : D204635041
 This Issue : 9/29/2006 S.O. No. : *N/A* Drawing Number : D2590 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : LANDING GEAR Drawing Revision : C
 Previous Run : 25691A Material : *N/A*
 Written By : Due Date : 10/22/2006 Qty: 1 Um: Each
 Checked & Approved By : *[Signature]*
 Comment : Est Rev: F 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25001190 Ext'n -1" Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2500-1-190 Skid Tube Extrusion *B25858*

DP 6-10-26

2.0 D2597 204 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2597 204 Web *B2880a*

MA 06/10/31

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2590 if necessary Deburr ends

3-Drill pilot holes using drill jig DT 8149 & DT8711-1&-2

4-Acid etch and Alodine tube per QSI 005 4.1

5-Open holes to 0.500" as per Dwg D2590 without cutting fluid

6-Countersink holes as per Dwg D2590 without cutting fluid

7-Deburr and blow out all chips from inside of tube

DP-6-10-26

MA 06/10/27 ①

PM 06-10-31 ①

PM 06-10-31 ①

PM 06-10-31 ①

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:38:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 28780A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M1102107 m-h 06/10/31

Sikaflex expire date: 07-02-01

Start Time: 11:00 AM

Fin Time: 7 AM

4.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend as per program D2590.C on CNC Bender

DP 6-11-6

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut tubes as per Dwg. D2590 .

DP 6-11-6

2-Deburr ends after cutting. Remove alodine from around holes

m-h 06/11/09 ①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 6-11-9

7.0

D25763

Step (Machining Detail);



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2576-3 Step

B 23060 BE 6-11-9

8.0

D2579

Crossbolt Spacer



Comment: Qty.: 17.0000 Each(s)/Unit Total : 17.0000 Each(s)

Pick:

Qty Part Number Description Batch
17 D2579 Spacers

B 27921 BE 6-11-9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:38:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 28780A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required. *m.d 06/11/09 ①*

2-Weld step D2576 as per Dwg. D2590 and QSI 004

A/R

Aluminum Rod

m101655 BE 06/11/09 ①

3-Weld crossbolt spacers D2579 as per Dwg. D2590 and QSI 004. For D2579

spacers, weld one

side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

m101655 BE 06/11/09 ①

4-Grind welds as per Dwg D2590 Grind flush ridge made from bending

Pm' 06-11-13 ①

5-Drill holes for wearplates using DT 8218 Open holes to 19/64", adjust stopper not to hit crosstubes. Deburr

Pm' 06-11-13 ①

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2590. Deburr holes

Pm' 06-11-13 ①

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr

Pm' 06-11-13 ①

8-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

Pm' 06-11-13 ①

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Inspect weld and Counterbore work to Step 20

Job 11-14 ①

M 06/11/14 ①

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

M 102 391

Yl u.m 06/11/20 X 1

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06/11/21 ①

13.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:38:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 28780A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1

D2577-1

Wearplate

B26350

14.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	<u>B28013</u>

15.0

D25777

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-7	Wearplate	<u>B24878</u> <u>B4978</u>

16.0

ALS71032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	ALS7-1032-130	Inserts	<u>M18990</u> <u>ALS4-1032-130</u>

17.0

AN960JD10L

Washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
<u>38</u>	AN960JD10L	<u>Inserts</u> <u>Washer</u>	<u>M100233</u> (18X) <u>M102217</u>

18.0

AN34A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN3-4A	Bolt	<u>M18369</u>

am 06/11/21 @

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:38:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 28780A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D25941

Plug



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

10 D2594-1

Plug

026364

20.0

D25943

O-Ring



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

10 D2594-1

Plug

027148

21.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

026351

22.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

M15205

23.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

M102217

a.m 06/11/21

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2590. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

Sikaflex expire date: 02/07

02660

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

a.m

06/11/21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/12/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:38:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 28780A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Install 2855 Aft Cap as per Dwg D2590 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 02/07

M 102660

a.m

06/11/21

(1)

5-Wing Walk as per Dwg D2590 and QSI 005 4.4

Batch:

M 102635

a.m

06/11/23

(1)

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

FC 061123 (1)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

FC 061123

Job Completion



C Loc 11/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2590	REV. C SHEET 1 OF 2
DATE 98.08.28		TITLE 204 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.28	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED
98/09/11 BS

QTY	Part Number	Description
X	D2590-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2597	204 WEB
1	D2575	AFT CAP
1	D2576-3	STEP
17	D2579	CROSS BOLT SPACER
10	D2594-1	PLUG
10	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-7	WEARSHOE
38	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
40	AN3-4A	BOLT
40	AN960JD10L	WASHER

00.08.28
P 00.08.28

DEOS	
EFFECTIVE	98/12/14

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 169.5 INCHES *
- 3) INSERT D2597 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-204 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (38 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2597 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28780A

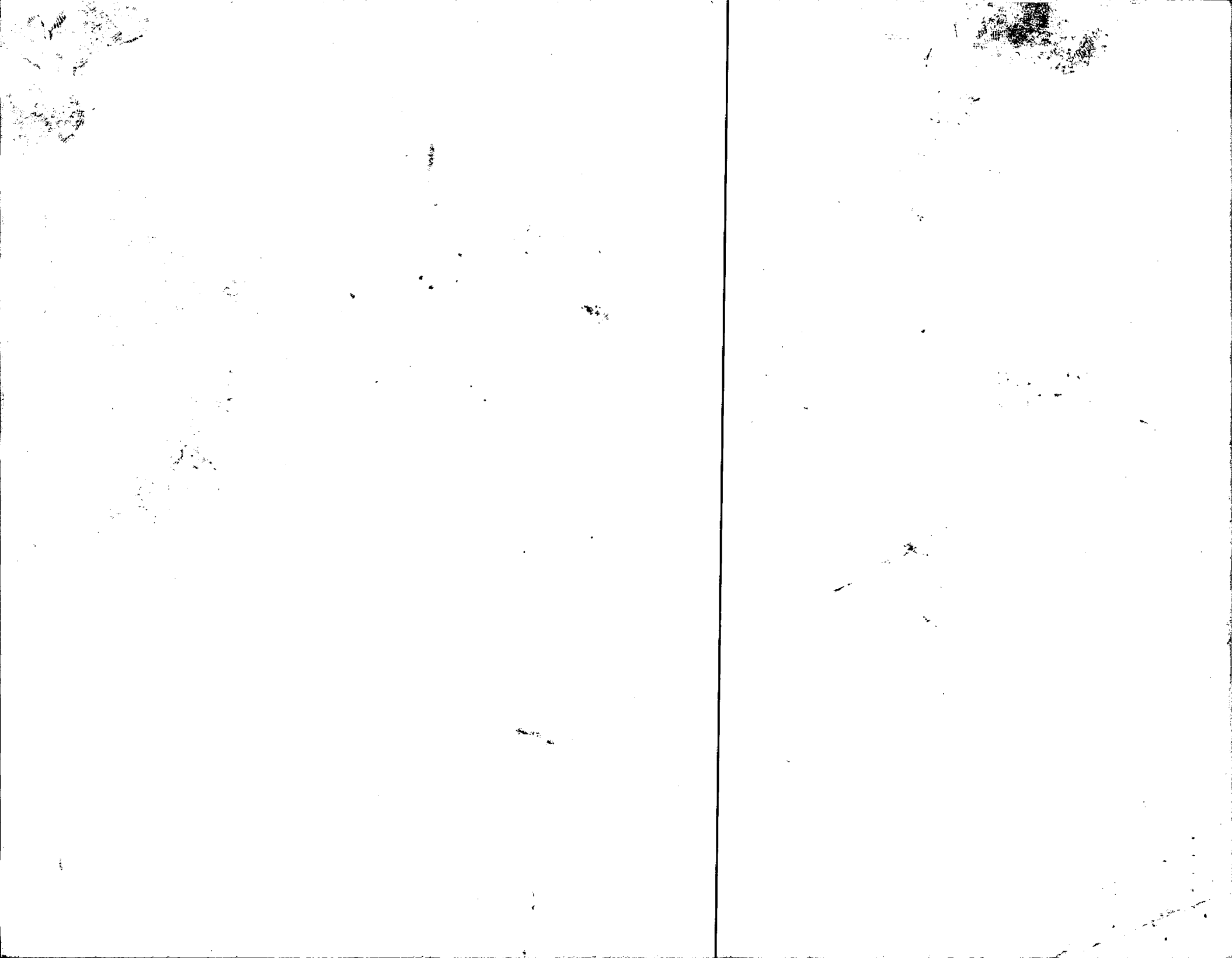


Diagram illustrating the grinding locations on a propeller cross-section. The locations are marked with arrows and labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- STEP
- \sqrt{X}

DRILL PRIOR TO D2575 CAP
INSTALLATION (2 PLACES)

AN3-4A BOLT (1)
AN96QD10L WASHER (1)
(2 PLACES)

D2575 CAP

SEAL WITH
SIKAFLEX-241

UNC
SUB

D2579 SPACER

WEB (REF)

130 (REF)
8 PLACES

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (17 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO #0.437 X 1.00 DEEP

This diagram shows the elevation view of the bridge deck with reinforcement details. Key dimensions include:

- Top Reinforcement:** #0.508 (TYP.) (34 PLACES) spaced at 9.00 inches.
- Bottom Reinforcement:** #0.508 (TYP.) (34 PLACES) spaced at 9.00 inches.
- Deck Thickness:** 16.5 inches (D2500-1).
- Reinforcement Spacing:** 36.000 inches (REF) for 4 equal spaces.
- Other Dimensions:** 37.50, 38.0, 71.000, 17.375, 26.000, 35.000, 8.750, 1.750, and 1.750.

[illegible]

D2577-471 ASSEMBLY DETAIL

0.5

1.5

1.5

D

0.5

1.5

1.5

1.5

1.5

REFER TO DETAIL C

D2577-3

D2577-7

D2577-1


AN3-4A BOLT (1)
AN960J010L WASHER (1)
(38 PLACES)

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

WELD AS PER DETAIL B

8

DESIGN <i>MB</i>	DRAWN BY <i>CP</i>	 DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED <i>MB</i>	APPROVED	
DRAWING NO. D2590		REV. C SHEET 2 OF 2
DATE 08.08.28	TITLE 204 SKIDTUBE ASSEMBLY SCALE 1:24	

NO. 73

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure TIG
Part number and Job number 204 635041/B28780 A

TEST WELDS REQUIRED

BASE METAL Alum

WELDING PROCESS TIG

Penetration Complete ☐ Partial ☒

Single Weld ☒ Double Weld ☐

Current AC ☒ DC ☐

Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐

Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/01/08

Qualifier David David